

EPINAMEL® DTM985

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Description

- A two-component, surface tolerant, high solids, direct-to-metal, high-build, polyamine adduct cured epoxy coating approved to APAS 2973.
- Conforms to AS/NZS 3750.14.
- Conforms to AS/NZS 4020:2018 (factory made white only).

Product Characteristics

- Maintenance coating for use in a wide range of industrial applications as a primer, build coat or finish coat.
- Tolerant to lower grades of steel preparation for atmospheric exposure.
- Excellent re-coatability.
- Cures down to 0°C with Low Temperature (LT) Part B.
- Excellent abrasion resistance.
- Resistant to splash of alkali, mineral oils, solvents and dilute acids.
- Suitable for immersion in salt and fresh water.
- Suitable for sewerage immersion applications such as wet wells and storage tanks (both for steel and concrete substrates).
- Can be applied to existing piling between tides or for new work.
- Can be exposed to water immersion shortly after application.
- Suitable with well-designed cathodic protection systems.

Colours and Gloss

- AS 2700 colour card, micaceous iron oxide colour range – gloss.
- Factory colours: white, black, N53 grey blue, Y14 golden yellow, MIO 802, MIO 814, MIO N53.
- Only factory manufactured white and black colours are suitable for immersion applications.

Recommended Film Thickness (Per Coat)

| | Minimum | Maximum | Typical |
|--|---------|---------|---------|
| Dry film thickness (µm) | 150 | 500 | 250 |
| Wet film thickness (µm) | 176 | 590 | 295 |
| Theoretical spreading rate (m ² /l) | 5.7 | 1.7 | 3.4 |

Basic Data at 25°C

| | |
|------------------------|---|
| Solids content approx. | 85% by volume |
| Mix ratio | 3A:1B by volume |
| Touch dry after | 3-4 hours (Std Part B) 2.5 hours (LT Part B) |
| Full cure | 5 days (Std Part B) 3 days (LT Part B) |

Surface Preparation

- All surfaces to be coated must be clean, dry and free from chalking and contamination.

PREVIOUS SUITABLE COAT

- Dry and free from any contamination and sufficiently roughened if necessary.
- Oil and grease should be removed from all surfaces in accordance with AS 1627.1 solvent cleaning.

MILD STEEL

- Blast clean in accordance with AS 1627.4 to Sa 2½ minimum (AS 1627.9), surface profile 40-70 microns.
- Power tool clean in accordance with AS 1627.2 to St 2 minimum (AS 1627.9), (atmospheric exposure only).

GALVANISED STEEL

- Lightly blast using an inert grit or power tool clean to achieve a roughened uniform flat appearance.

CONCRETE

- Must be free from bond breakers, curing agents or any other contaminants that may interfere with adhesion.
- Acid etch to remove all laitance (atmospheric exposure only).
- Blast clean to remove all laitance.
- Moisture content of concrete should be max. 4%.
- Ensure all new concrete is fully cured prior to coating. Typically, this may take a minimum of 4-6 weeks.

Application Instructions

- Mixing ratio by volume: 3A:1B.
- Mix Epiname DTM985 Part A with Epiname DTM985/DTS680 Standard or Low Temperature (LT) Part B only.
- Induction time – none.
- Pot life at 25°C: 2 hours (Std Part B), 45 min (LT Part B).
- Stir the components and mixed product well using a mechanical mixer.
- Low temperature Part B is not recommended for use at Temperatures above 35°C.
- The temperature of the mixed product must be above 15°C, otherwise extra thinner may be required to obtain application viscosity.
- Too much thinner will result in lower sag resistance and slower cure.
- Thinner should only be added after mixing the components.
- Freshly catalysed material should not be added to product that has been mixed for some time.
- Wattyl recommends the use of coating inspection reports in compliance with AS/NZS 3894.10,11,12 refer to Information Sheet I-20 for more information.
- for recommendations outside those contained in this data sheet, refer to Wattyl.

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Application Methods

| | AIRLESS SPRAY | AIR SPRAY | BRUSH/ROLLER Only for touch up and spot repair |
|-------------------------|--------------------------------------|-------------------------------------|---|
| Recommended thinner | Thinner L760 | Thinner L760 | Thinner L760 |
| Volume of thinner | 0-10% | 0-10% | 0-10% |
| Tip | 0.53-0.58mm (0.021-0.023 inch) | 1.5-2.0mm (0.059-0.0078 inch) | <ul style="list-style-type: none"> The maximum dry film thickness that can be achieved when brushing/rolling is 100 microns. |
| Fluid/Atomised pressure | 15 MPa (2100 psi) | 0.2-0.4 MPa (30-60 psi) | <ul style="list-style-type: none"> Nylon/polyester or natural bristle brushes recommended. |
| Pump | 30:1 | - | <ul style="list-style-type: none"> Recommended roller cover should be 10mm woven with a solvent resistant core. |
| Hose | ¼" ID (6.3mm) | - | |
| Filter | 60 mesh | - | |

CLEANING SOLVENT | Thinner L760

Note: In warmer conditions, replace some or all of Thinner L760 with Thinner L765 (slow thinner).

- If spraying for extended periods or if stopping work it is recommended to intermittently flush out spray lines.

Safety Precautions

- Flammable. Avoid contact with heat and naked flame.
- Avoid contact with skin and eyes.
- Use gloves, mask and goggles during application.
- Provide adequate ventilation when using in confined spaces.
- This product is intended for use in industrial situations by professional applicators in accordance with the advice given on this sheet. All work involving the use and application of this product should be carried out in compliance with all relevant Health, Safety & Environmental standards and regulations and must not be used without reference to the safety data sheet (SDS).

Additional Data

OVERCOATING TABLE

Overcoating interval for EpinameL DTM985 cured with Standard Part B when top coating with **EpinameL DTM985**.

| Interval | 5°C | 15°C | 25°C | 35°C |
|----------|--------|--------|--------|--------|
| Min | 16 hrs | 6 hrs | 3 hrs | 2 hrs |
| Max | 3 mths | 3 mths | 2 mths | 2 mths |

Overcoating interval for EpinameL DTM985 cured with LT Part B when top coating with **EpinameL DTM985**.

| Interval | 5°C | 10°C | 15°C | 25°C |
|----------|--------|--------|--------|--------|
| Min | 8 hrs | 5 hrs | 3 hrs | 1½ hrs |
| Max | 3 mths | 2 mths | 2 mths | 1 mth |

Overcoating interval for EpinameL DTM985 cured with Standard Part B when top coating with **two-pack polyurethanes**.

| Interval | 5°C | 15°C | 25°C | 35°C |
|----------|--------|-------|-------|-------|
| Min | 16 hrs | 8 hrs | 4 hrs | 2 hrs |
| Max | 1 mth | | | |

Overcoating interval for EpinameL DTM985 cured with LT Part B when top coating with **two-pack polyurethanes**.

| Interval | 5°C | 10°C | 15°C | 25°C |
|----------|-------|-------|---------|---------|
| Min | 8 hrs | 6 hrs | 4 hrs | 2 hrs |
| Max | 1 mth | 1 mth | 14 days | 14 days |

Overcoating interval for EpinameL DTM985 cured with Standard Part B when top coating with **Paracryl IF540**

| Interval | 5°C | 15°C | 25°C | 35°C |
|----------|--------|-------|---------|--------|
| Min | 16 hrs | 8 hrs | 4 hrs | 2 hrs |
| Max | 1 mth | 1 mth | 14 days | 7 days |

Overcoating interval for EpinameL DTM985 cured with LT Part B when top coating with **Paracryl IF540**

| Interval | 5°C | 10°C | 15°C | 25°C |
|----------|---------|---------|--------|--------|
| Min | 8 hrs | 6 hrs | 4 hrs | 2 hrs |
| Max | 14 days | 14 days | 7 days | 7 days |

CURING AND POTLIFE TABLE

Curing and Potlife Table for EpinameL DTM985 cured with Standard Part B.

| Paint temperature | 5°C | 15°C | 25°C | 35°C |
|-----------------------------------|---------|--------|--------|--------|
| Dry to handle | 24 hrs | 12 hrs | 6 hrs | 3 hrs |
| Full cure | 14 days | 7 days | 5 days | 3 days |
| Potlife (at applicable viscosity) | 8 hrs | 4 hrs | 2 hrs | 1 hr |

Curing and Potlife Table for EpinameL DTM985 cured with LT Part B.

| Paint temperature | 5°C | 15°C | 25°C | 35°C |
|-----------------------------------|---------|--------|---------|------|
| Dry to handle | 12 hrs | 5 hrs | 3 hrs | NR |
| Full cure | 12 days | 5 days | 3 days | NR |
| Potlife (at applicable viscosity) | 3 hrs | 1½ hrs | 45 mins | NR |

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- Adequate ventilation must be continuously maintained during application and curing.
- Suitable for application between tides, allow 30 minutes set up time before immersion.
- Coating will continue to cure when immersed in water.
- Premature exposure to water may cause colour or gloss change but will not affect the coating performance.

Precautions

- For recommendations outside those contained in this data sheet, refer to Wattyl.

Product Compatibility

PRIMERS

- Galvit ES510
- EpinameL PR250
- EpinameL PR360ZPS

TOPCOATS

- EpinameL DTM985
- Poly U400 (colours)
- Poly U750 (colours)
- Paracryl IF540 (colours)

Storage and Packaging

- Shelf life at least 12 months.
- All components shall be stored in a dry internal environment at between 5°C and 35°C.
- Packaging: 20 litre kit (15 litre Part A, 5 litre Part B)
4 litre kit (3 litre Part A, 1 litre Part B)
- Product line: 2007.

For the most up to date information, please visit our website at www.wattylpc.com.au, or contact us at Australia 132 101 (Australia) 0800 825 7727 (New Zealand).

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